



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18635-5
Job Sheet 175521



Part No: RBT18635-5

Job Qty: 10 ea

Part Name: Rod



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18635 Rev 2A IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/12/18	0.00	0.00	Start Up Machining-4		JB 18-05-11
120	Lathe Conv	10 pcs		4/13/18	0.00	0.83	Lathe Conv-2		JB 18-05-11
130	QC	10 pcs		4/13/18	0.00	0.00	QC2 Machining-5		JB 18-05-11
140	QC	10 pcs		4/13/18	0.00	0.00	QC8 Machining-5		JB 18-05-11
150	Outsource	10 pcs		4/13/18	0.00	0.00	Outsource12		CT 18-05-14
160	Packaging	10 pcs		4/13/18	0.00	0.00	Packaging2		AT 14-05-16
170	QC	10 pcs		4/13/18	0.00	0.00	QC6		
180	Packaging	10 pcs		4/13/18	0.00	0.00	Packaging3-2		18-05-17 GA 145
190	QC21-SA	10 Ea		4/13/18	0.00	0.00	QC21		21 MAY 17 2018

Part Op 120 - Machine as per DWG.

Descriptions: 150 - Issue P/O to Groupe Altech; PO 032693 - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. - Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-H0.250	AISI 1144 Stressproof Steel Hex Bar 0.250"	5.1600 (.516 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-H0.250 M1018R0.250	5	0	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 9:25 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

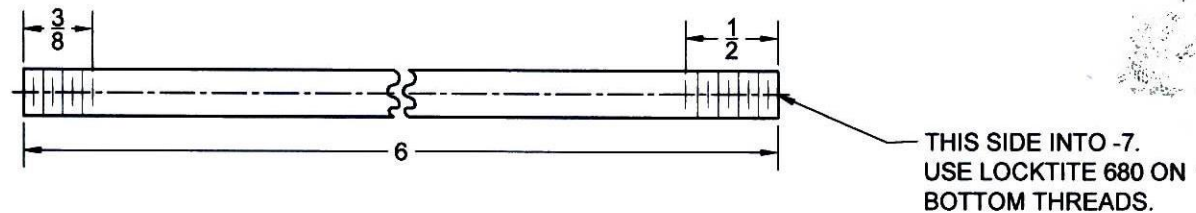
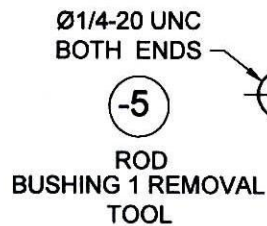
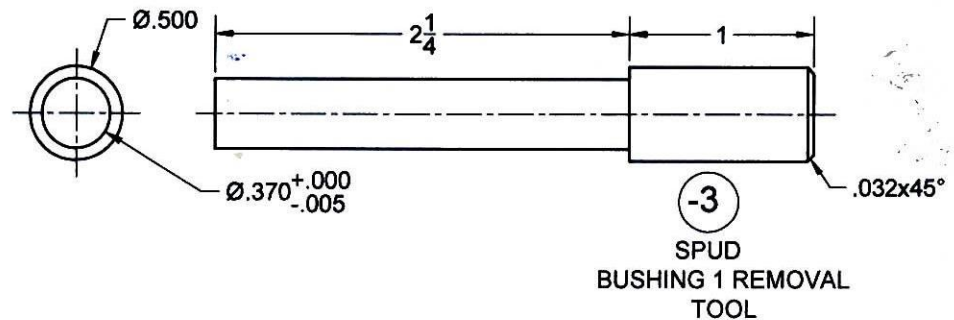
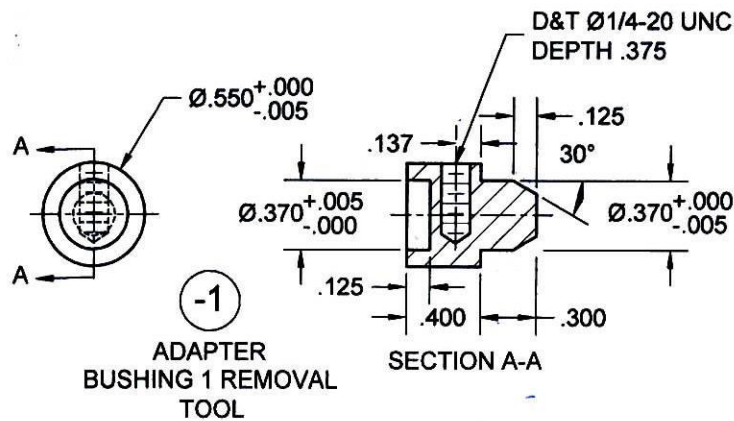
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED .125 x 30° TO -1 ADAPTER.	1/15/07		
2	CHANGED -11 R.063 TO CHAMFER & -7 MAT. FROM 1018.	1/13/07		
2A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, CH'D ENGRAVE NOTE -7 & -11.	1/21/10	RJC	RW



ASSY QTY	ASSY QTY	B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	ADAPTER BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø9/16 x 3/4	1
			-3	1	SPUD BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø1/2 x 3-3/8	1
			-5	1	ROD BUSHING 1 REMOVAL TOOL	1018	Ø1/4 x 6-1/8	1
			-7	1	HANDLE BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø3/4 x 3-1/8	2
			-9	1	SPUD BUSHING 2 REMOVAL TOOL	STRESS PROOF	Ø9/16 x 3-1/8	2
			-11	1	BUSHING RECEIVER	6061	Ø1-1/4 x 3-1/8	2
ASSY #								

RED BARN MACHINE	
TITLE T/R BLADE BUSHING REMOVAL TOOL	
DWG NO. RBT18635	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-16-06
SHEET 1 of 2	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Container No: S070807 Part: RBT18635-5 Job No: 175521 Serial No/Batch: S070807 Revision: 2A Inspector:	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ To Fab ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
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Composite ☐	Supplier ☐																
		MRB (QSI042) Approval															
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		Lead hand / Supervisor Approval Verification															
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OTHER : _____																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039893**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039893
PO Date: 5/14/18
Due Date: 5/16/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173856	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/16/18	10 pcs	0 pcs 10x	10 pcs	\$5.41/pcs	\$54.10
2	173891	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/16/18	10 pcs	0 pcs 10x	10 pcs	\$2.65/pcs	\$26.50
3	175521	RBT18635-5	Rod -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	5 pcs	0 pcs 5x	5 pcs	\$2.05/pcs	\$10.25
4	175524	RBT18635-9	Spud -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	5 pcs	0 pcs	5 pcs	\$2.40/pcs	\$12.00

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(009320-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009320 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-May-2018		Aman		039893				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3303-02-1 Rev.	RBE350A93-3303-02-1 01-BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
2	RBE350A93-3303-02-3 Rev.	RBE350A93-3303-02-3 01-BLACK OXIDE MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
3	RBT18635-5 Rev.	RBT18635-5 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	5	5	0	0	0
4	RBT18635-9 Rev.	RBT18635-9 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5	0	0	0
6	RB AN8514-1-5 Rev.	RB AN8514-1-5 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	3	3	0	0	0
8	RB AN8515-1-7 Rev.	RB AN8515-1-7 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4	0	0	0
9	RB AN8515-1-5 Rev.	RB AN8515-1-5 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	4	4	0	0	0
10	RB AN8514-1-4 Rev.	RB AN8514-1-4 01-BLACK OXIDE MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	3	3	0	0	0
11	RB AN8515-1-2 Rev.	RB AN8515-1-2 01-BLACK OXIDE MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	3	3	0	0	0